

FIG. 1 TOP VIEW - COVER REMOVED

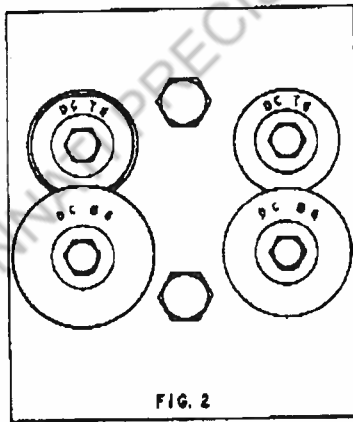
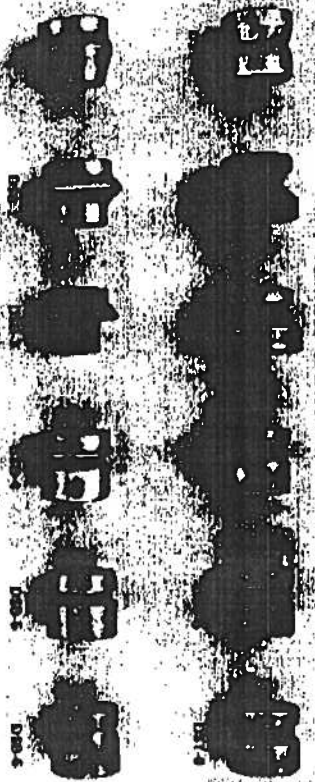
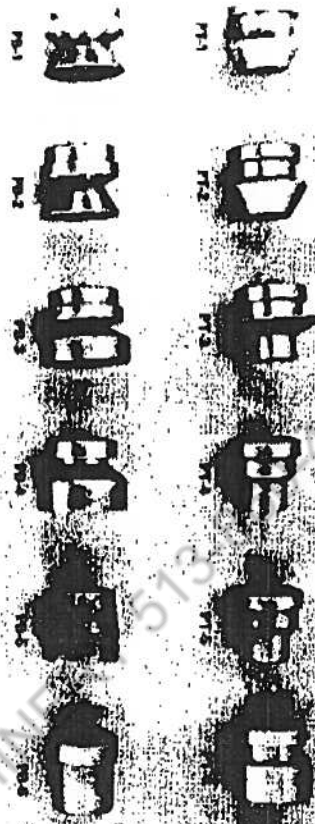


FIG. 2

GAUGE SET UP CHART

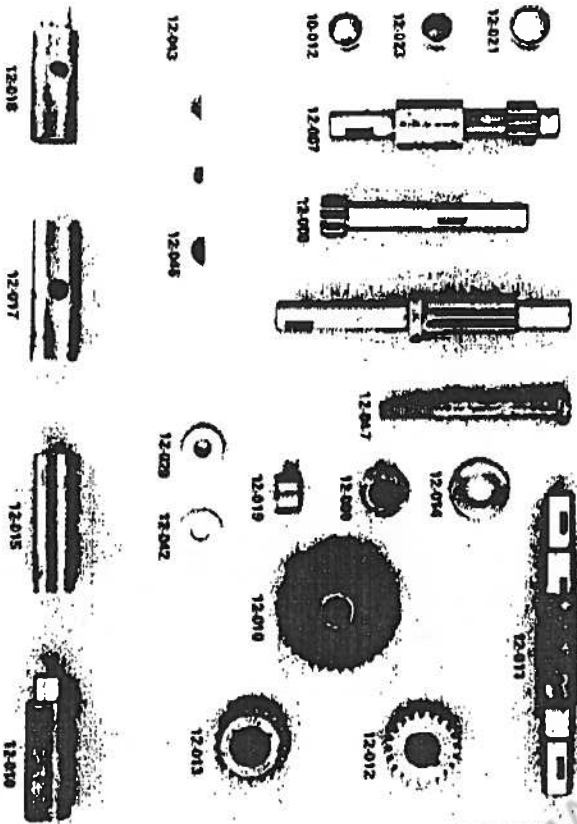
	PITTSBURGH LOOK	DOUBLE SEAM	RIGHT ANGLE FLANGE
MATERIAL ALLOWANCE (APPX.)	1"	1"	TO SUIT
22-24 GAUGE SET (APPX.)	1 3/4" (FOR 7/32 HAMMER OVER EDGE)	1 1/8" (MAX.)	1 1/16" (3/8" HEIGHT MAX.)
26-28 GAUGE SET (APPX.)	1 13/16"	1 3/16"	1"

FOR DRIVE GLEAT ROLLS SHEAR MATERIAL 2 1/8" MAX. SET FEED GAUGE STRAIGHTEDGE 3/4" FROM EDGES OF ROLLS (FIG. 1).



PORTABLE 22 GAUGE DOUBLE SEAM

PORTABLE 22 GAUGE DRIVE CLEARIS



72

PARTS LIST

FOR

FLAGLER 22 GAUGE PORTABLE PITTSBURGH MACHINE

<u>OLD PART NO.</u>	<u>NEW PART NO.</u>	<u>DESCRIPTION</u>	<u>AMOUNT REQ'D.</u>
	12-001	TOP FRONT PLATE	1
B-1	12-002	TOP BACK PLATE	1
B-2	12-003	BOTTOM FRONT PLATE	1
B-3	12-004	BOTTOM BACK PLATE	1
B-4	12-005	NO. 1 PINION GEAR	1
B-8	12-006	NO. 2 PINION GEAR	1
B-9	12-007	NO. 3 PINION GEAR	1
B-10	12-008	PINION COLLAR	4
B-29	10-006	PINION COLLAR	1
B-29	12-010	36 TOOTH BULL GEAR	2
B-7	12-011	ROLL SHAFT	12
B-11	12-012	ROLL SHAFT GEAR	12
B-5	12-013	IDLER GEAR	5
B-6	12-014	THRUST COLLAR	12
B-12	12-015	PLAIN SPACER	4
B-18	12-016	PLAIN STEP SPACER	3
B-19	12-017	PLAIN DRILLED SPACER	2
B-20	12-018	TAPPED STEP SPACER	2
B-21	12-019	SADDLE WASHER	2
B-22	12-020	LEATHER WASHER	2
B-23	12-021	BEARING B-148	24
B-31	10-012	BEARING B-128-O.H.	6
B-32	12-023	BEARING B-1210	5
B-33	12-024	ANGLE IRON BRACKET	2
B-35	12-025	COVER ASSEMBLY	1
B-54	12-028	CABINET ASSEMBLY	1
B-52	10-032	1/2 H.P. MOTOR	1
B-46	12-039	MOTOR PULLEY	1
B-44	12-040	HEAD PULLEY	1
B-45	12-041	"V" BELT	1
B-43	10-036	CORD	1
B-49	10-037	CONNECTOR	1
B-48	10-038	SWITCH	1
	10-039	SWITCH COVER	1
	12-042	HOLD DOWN WASHER	2
	12-043	GREASE FITTING	4
B-55	12-044	NO. 61 WOODRUFF KEY	12
B-14	12-045	3/16" DIA. x 3/8" LONG PIN	12
B-13	12-046	NO. 9 WOODRUFF KEY	3
B-15	12-047	HOLD DOWN STUD	2
B-25			

WIRING INSTRUCTIONS

The motor used on this machine can be used on either 110 or 220 volts, and is generally wired at the factory for 110 volt current. Diagrams for change of voltage are on the motor. The recommended fuses for the machine is 25 A. If necessary to use an extension cord between the cord of the machine and the outlet box, the wire gauge must not be less than #14 ga. for 25 foot, #12 ga. for the next 50 Ft.

INSTALLATION OF FORMING ROLLS

PITTSBURGH LOCK, RIGHT ANGLE FLANGE, AND DOUBLE SEAM OR ACME FORMS
In general, installation of any of these sets of rolls is the same. Pittsburgh lock rolls are generally installed at the factory, but the following will be helpful for auxiliary sets. Mount angle feed gauge and riser plate, if not already on machine. All rolls are identified by stampings on the outside end of the rolls, the letter and number corresponding to the position on the machine, that is to say, #T-1 roll is the TOP, or upper roll in the first set; #B-1 is the bottom roll in the first set; T-2 is the top roll in the second set, and so on (see fig. 1). These rolls are mounted on their corresponding shafts, with the numbered side faced out from the machine (this is very important) and held in place with the screws and washers provided for them. Be sure all keys are in place; tighten rolls down securely and then proceed to adjust the gauges as per the adjustment instructions.

DRIVE CLEAT ROLLS

Drive cleat rolls are installed on the side of the machine as shown in fig. 1. Remove angle feed gauge and riser plate if on this side. Mount the drive cleat feed gauge into position (Fig. 1). Mount rolls on shafts as per instructions above, leaving roll (DC-T-3 free to float without a screw or washer, but with the key in place. Tighten all other rolls securely. Adjust the drive cleat feed gauge as per adjustment instructions. The angle slides which were previously furnished with these rolls has been replaced by the slide plate which is to be mounted on the exit end of the machine with the hardware provided.

ADJUSTMENT INSTRUCTIONS

To make any adjustments on rolls, remove top cover. Hold down studs must be tight for all standard gauges. If aluminum is used, it may be necessary to loosen holddown screws slightly to avoid distortion of material.

PITTSBURGH ETC.

Angle feed gauge settings are best made by laying a straight edge along the outside faces of the rolls and suitably measuring from the straight edge as shown in Fig. 1. After the gauge is bolted in position, push riser plate tight against the feed gauge and tighten down screws. See set up chart for dimensions.

DRIVE CLEAT

Drive cleat rolls feed gauge is set by laying a straight edge on the outside of the gauge and measuring to the faces of the rolls $3/4$ " , see figure 1. The slide plate adjustment is made by trial and error, due to the difference of physical qualities of various materials. If the finished cleat bows up adjust "Down" as shown in figure 2; If material bows down adjust slide "Up". Very little movement is needed for proper adjustment.

GENERAL OPERATING INSTRUCTIONS

Make sure that all adjustments are completed per the adjustment instructions. Start machine and run material into the forming rolls, taking care to hold material snugly against the angle feed gauge (fig. 1). It is of great importance when forming long sheets especially, to start the material into the rolls squarely. If the material runs out in either direction check the feed gauge for parallel. If material used is aluminum, see instructions covering adjustments.

1-3-63 AM

PORTABLE PITTSBURGH
12-000 SERIES

PART # 12-018
ROLL SHAFT
GEAR

PART # 12-014
ROLL SHAFT THRUST
COLLAR

PART # 12-011
ROLL SHAFT

PART # 12-013
IDLER GEAR

PART # 12-023
BEARINGS

PART # 12-016
STEP WRENCH

PART # 12-010
BULL GEAR

PART # 12-008
PINION COLLAR
& PLACES

PART # 12-007
3 PINION

PART # 12-006
2 PINION GEAR

PART # 10-012
BEARING
& PLACES

PART # 12-009
BULL GEAR

PART # 12-005
1 PINION GEAR

